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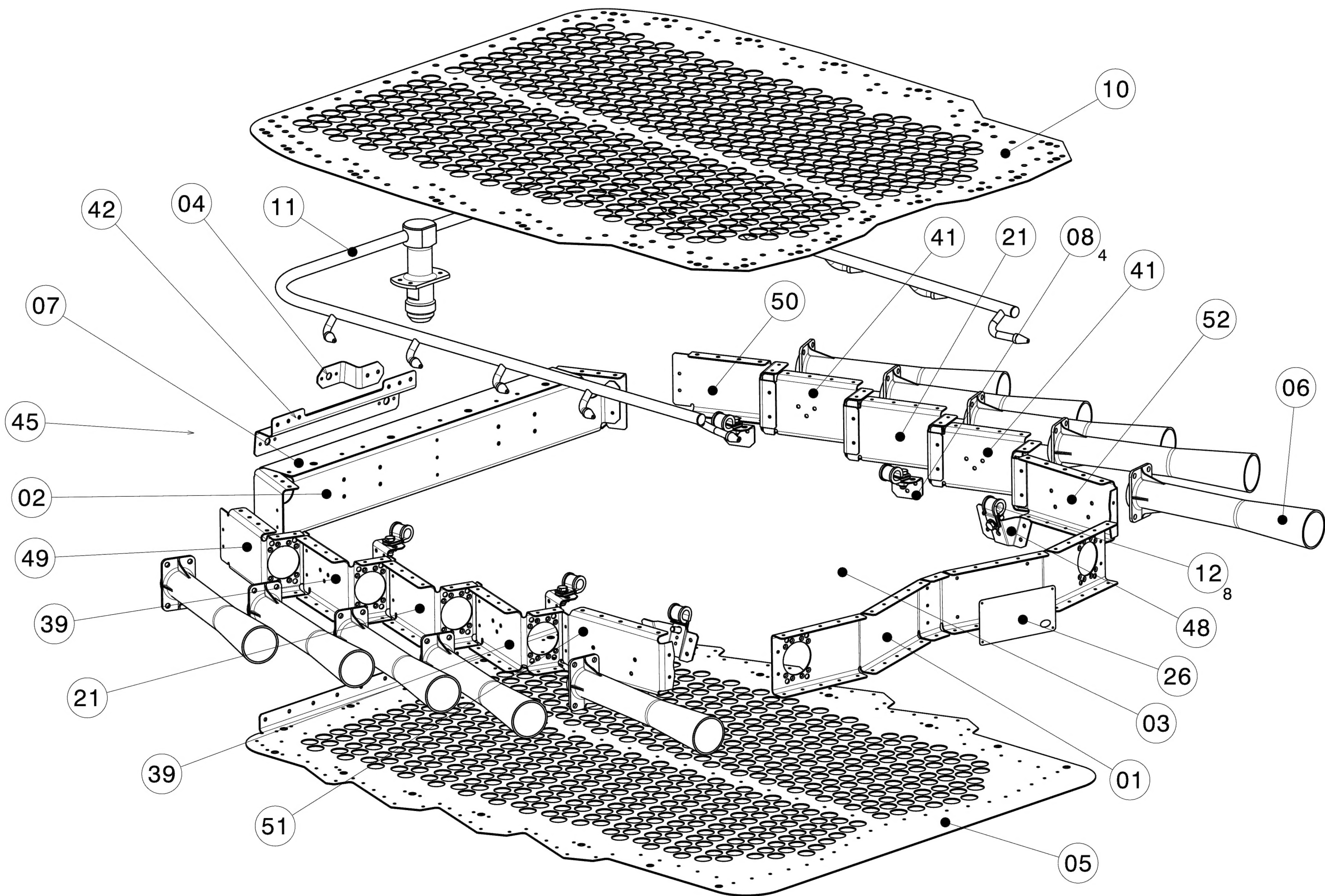
C

B

A

DRG NO		QB21304	SH	A * D	ISS	22	1	
ZONE	ISS	DESCRIPTION			DATE		APPROVALS	
ALL	22	REMOVED 10 ANCHOR NUTS REF 13 REMOVED 20 ANCHOR NUTS REF 16 CORRECTED THE TOTALS OF REFS 13 & 16 ECR R39101 INCORPORATED			25 MAR 2014	MODIFIED	B MITCHEM	
		CHANGE CODE: P1			28 MAR 2014	DRG CHCK:	T CLARK	
						PROJ ENGR:		
						MFG ENGR:		
						TECH APPL:		
						DSGN APPL:		
					28 MAR 2014	DSGN APPL:	D P SMITH	

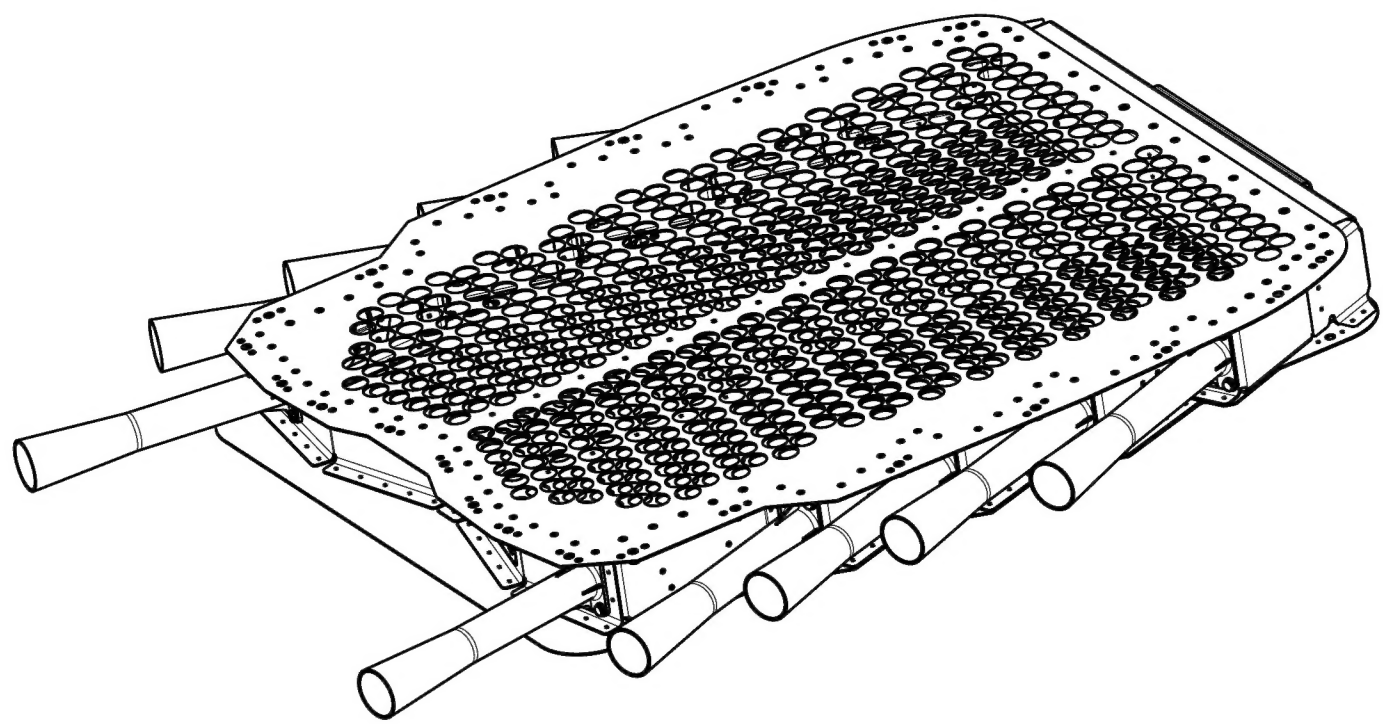
- ☐ RIVET TOGETHER ()
- ☐ * SPOT THRO' REF ()
- ☐ + OPEN OUT HOLES IN REF ()
- ☐ x HEAD ADJACENT TO REF ()
- ☒ CSK ADJACENT TO REF ()



EXPLODED VIEW
REF 05, 13, 14, 15, 22, 23, 24, 25, 29, 30
OMITTED FOR CLARITY
N.T.S

NOTES:



1. FINISH:- PRIOR TO FINAL ASSEMBLY, ENSURE ALL ALUMINIUM PARTS HAVE BEEN PRIMED USING REFS 32-34 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. EJECTORS, REF 06 & VORTEX/OUTLET TUBES, REFS 22, 23 & BRACKETS REF 48 TO BE LEFT AS NATURAL FINISH.
2. PAINT ALL PRIMED EXTERNAL SURFACES USING REFS 35-37 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS.
3. ASSEMBLE I.A.W. ASSEMBLY MANUAL.
4. ALL DISSIMILAR METALLIC INTERFACES TO BE WET ASSEMBLED USING DURALAC (REF 31). PARTICULAR CARE MUST BE TAKEN TO ENSURE A FULL COATING ON ALUMINIUM/STEEL INTERFACES. SPECIFIC AREAS OUTLINED IN DRAWING VIEWS.
5. ALL INTERFACING FLANGES AND RIVETS ARE TO BE WET SEALED USING 750C SEALANT (REF 19). REMOVE EXUDED EXCESS.
6. RIVET HOLES TO QD1028. RIVET TO QD5104.
7. ASSEMBLE VORTEX TUBES (REF 22) TO INLET TUBE PLATE (REF 10) TO QD5059 AND HEAT FLARE.
8. ASSEMBLE OUTLET TUBES (REF 23) TO OUTLET PLATE (REF 05) TO QD5059. DO NOT HEAT FLARE.
9. NOTCHES AND GAPS TO BE SEALED USING 750C SEALANT (REF 19).
10. TORQUE VALUES FOR FIXINGS:
M4: 2.25Nm MIN, 2.75Nm MAX
M5: 4.0Nm MIN, 5.0Nm MAX
11. LOCTITE FASTENERS (REF 24) & (REF 29) USING REF 38 WHERE SHOWN.



ISOMETRIC VIEW
N.T.S.

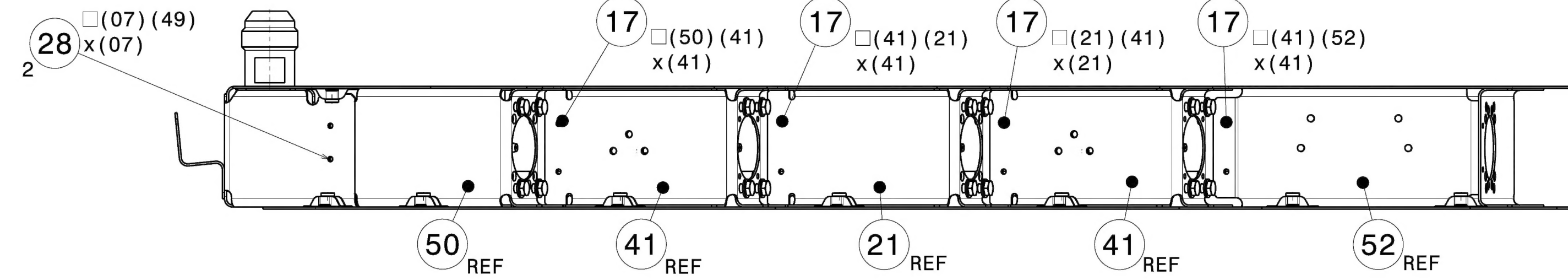
PART MARK
TO QD5016

1 & 4

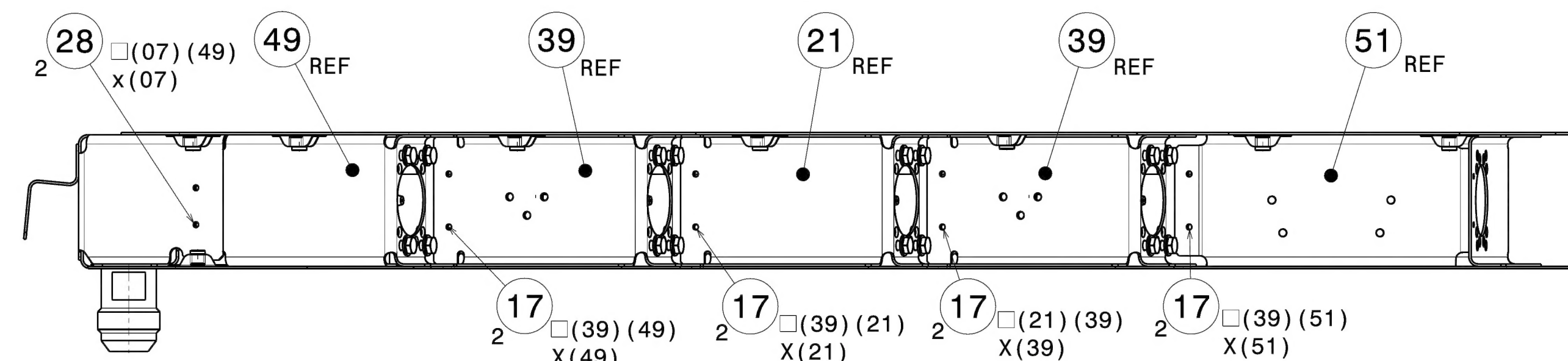
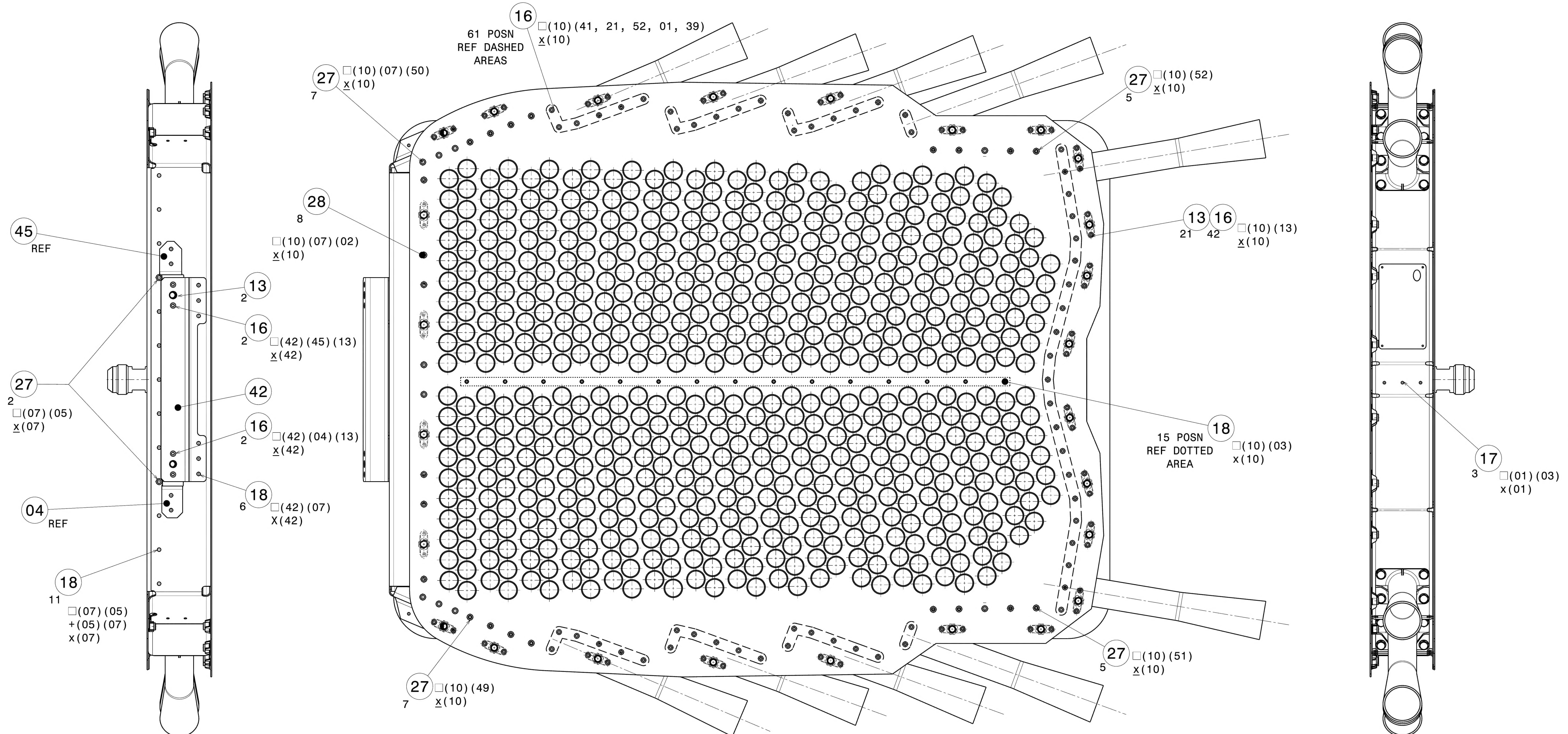
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	TOLERANCES ARE:				DRG BY	A SMITH	17 APR 2013	PALL AEROPOWER ENGINEERING, PORTSMOUTH, ENGLAND											
	DECIMALS				DRG CHCK	T CLARK	17 APR 2013												
	ANGLES				PROJ ENGR														
	X. ± 1.0		APPLICATION	MFG ENGR	TITLE ASSEMBLY SEPARATOR														
	.X ± 0.5																		
	.XX ± 0.25																		
	.XXX ± -																		
	SURFACE FINISH		NEXT ASSY QB05008	DSGN APPL	TECH APPL	DSGN APPL	SIZE A1	CAGE CODE U0088	DRG NO QB21304	ISS 22									
	3.2																		
DO NOT SCALE DRAWING		USED ON AS 350									CONTRACT NO AS 350		SCALE 1:2		WEIGHT		SHEET A OF D		

- ☐ RIVET TOGETHER ()
- * ☒ SPOT THRO' REF ()
- + ☐ OPEN OUT HOLES IN REF ()
- x ☐ HEAD ADJACENT TO REF ()
- x ☐ CSK ADJACENT TO REF ()

REFS 06 HAVE BEEN REMOVED FOR CLARITY



ZONE	ISS	DESCRIPTION	DATE	APPROVALS
ALL	2Z	REMOVED 10 ANCHOR NUTS REF 13 REMOVED 20 ANCHOR NUTS REF 16 CORRECTED THE TOTALS OF REFS 13 & 16 ECR R39101 INCORPORATED	25 MAR 2014	MODIFIED: B MITCHEM
		CHANGE CODE: P1	28 MAR 2014	DRG CHCK: T CLARK
				PROJ ENG:
				MFG ENGR:
				TECH APPL:
				DSGN APPL:
			28 MAR 2014	DSGN APPL: D P SMITH





REFS 06 HAVE BEEN REMOVED FOR CLARITY

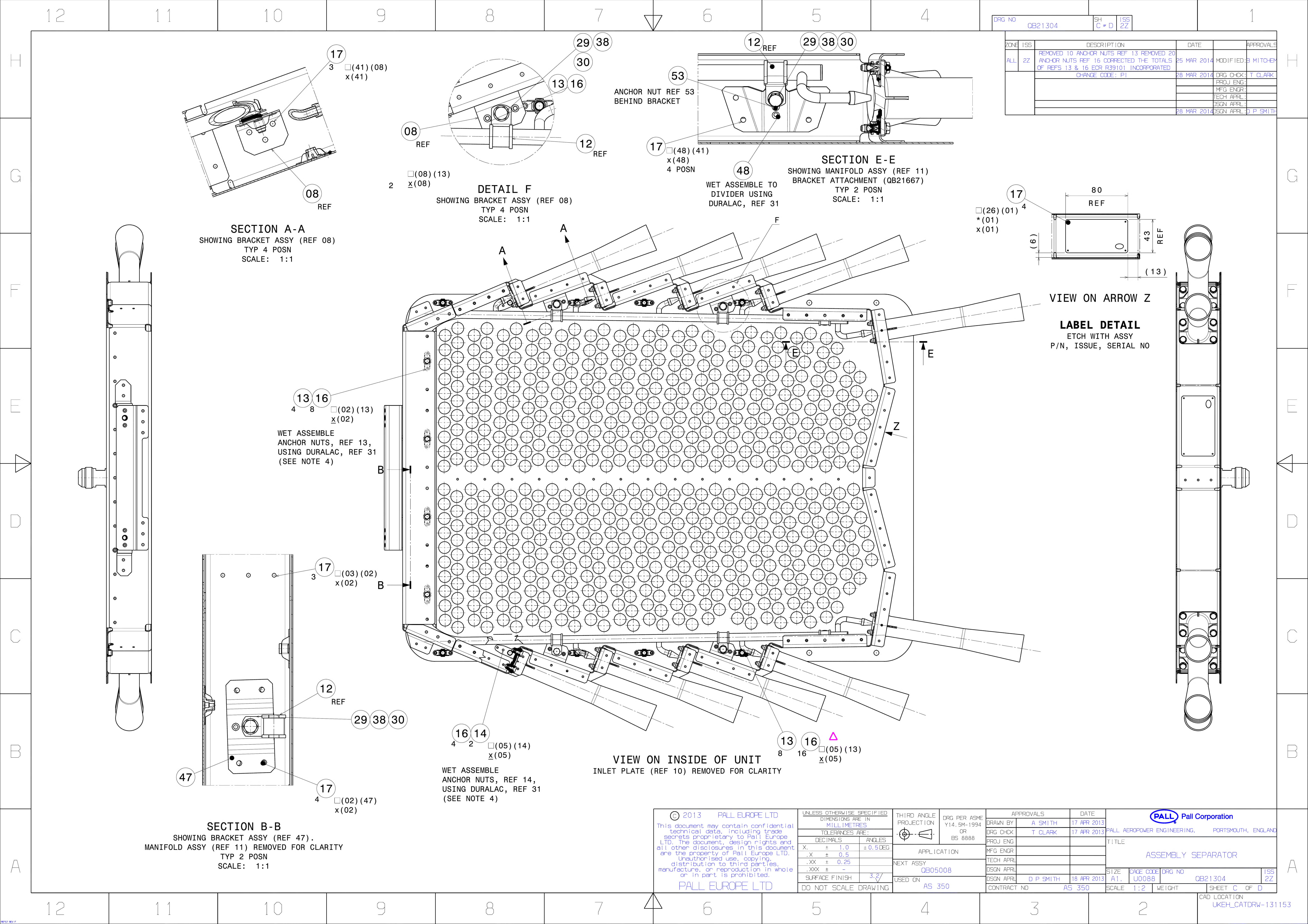
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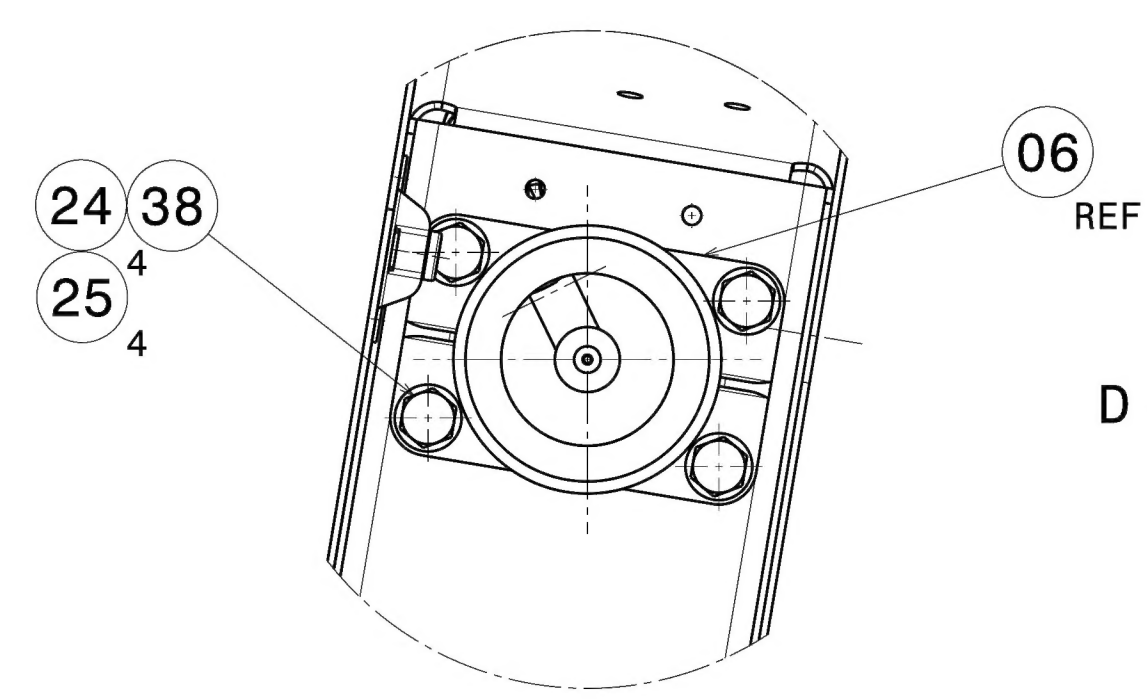
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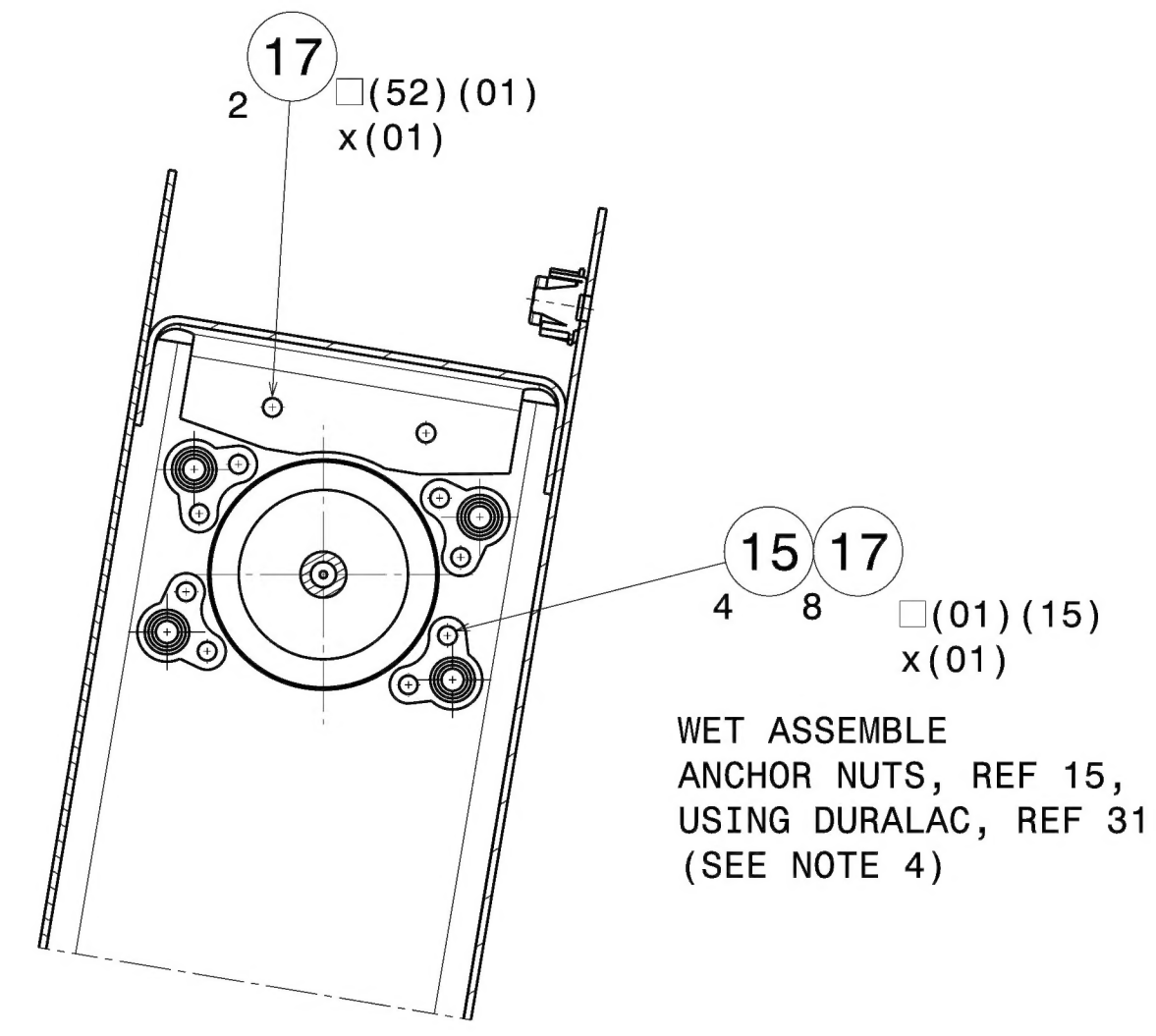
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETRES		THIRD ANGLE PROJECTION 	DRG PER ASME Y14.5M-1994 OR BS 8888		APPROVALS		DATE		 Pall Corporation PALL AEROPOWER ENGINEERING, PORTSMOUTH, ENGLAND			
TOLERANCES ARE IN					DRAWN BY	A SMITH	17 APR 2013					
DECIMALS		ANGLES				DRG CHCK	T CLARK	17 APR 2013				
X. ± 1.0		± 0.5 DEG		APPLICATION		PROJ ENG			TITLE			
.X ± 0.5				NEXT ASSY		MFG ENGR			ASSEMBLY SEPARATOR			
.XXX ± 0.25				OB05008		TECH APPL						
.XXX ± -				USED ON		DSGN APPL			SIZE	CAGE CODE	DRG NO	ISS
SURFACE FINISH		3.2		AS 350		DSGN APPL	D P SMITH	18 APR 2013	A1.	U0088	OB21304	2Z
DO NOT SCALE DRAWING						CONTRACT NO		AS 350	SCALE	1:2	WEIGHT	SHEET R OF D



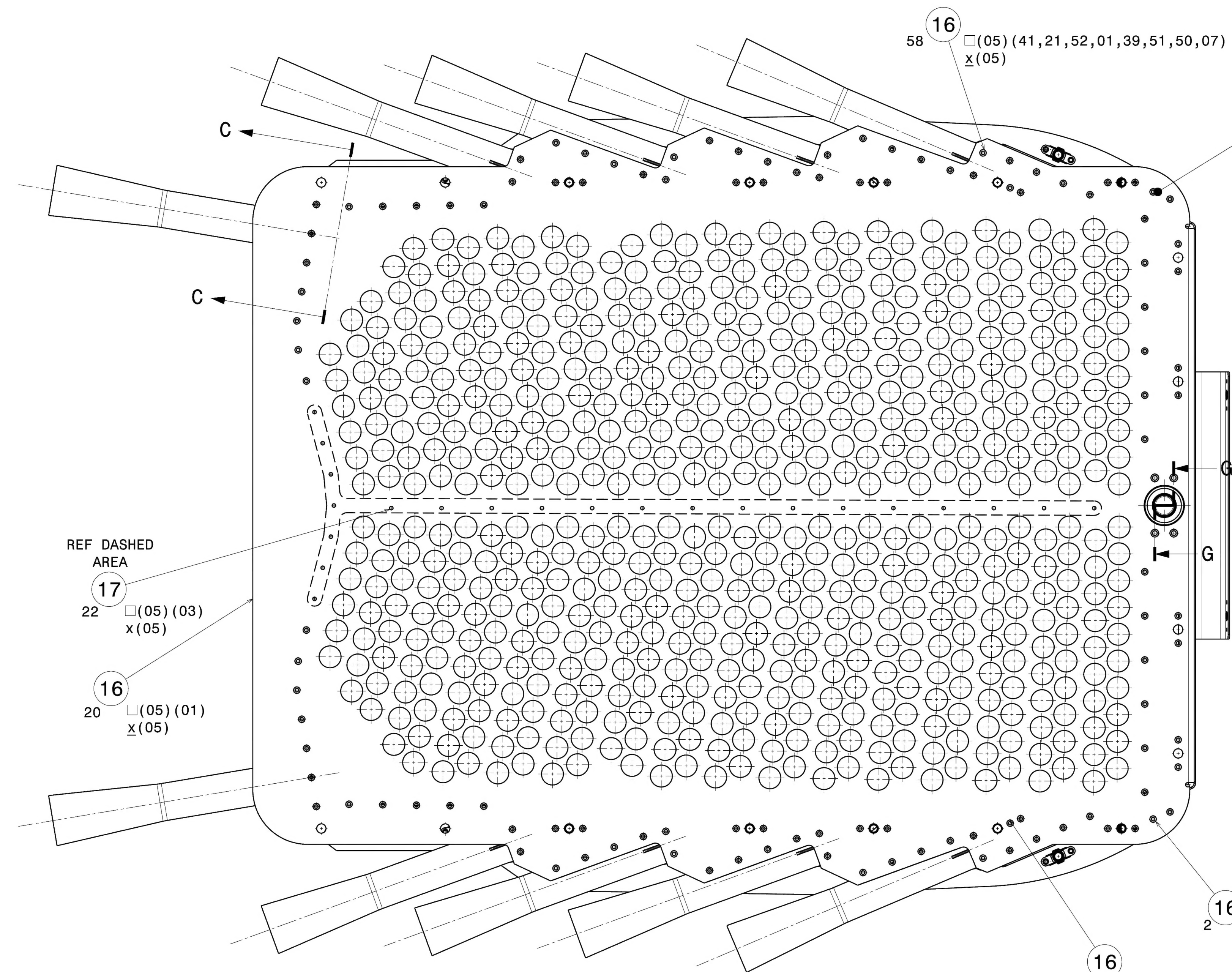
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ZONE	ISS	DESCRIPTION		DATE		APPROVALS
ALL	2Z	REMOVED 10 ANCHOR NUTS REF 13 REMOVED 20 ANCHOR NUTS REF 16 CORRECTED THE TOTALS OF REFS 13 & 16 ECR R39101 INCORPORATED		25 MAR 2014	MODIFIED	B MITCHEM
		CHANGE CODE: P1		28 MAR 2014	DRG CHCK:	T CLARK
					PROJ ENGR:	
					MFG ENGR:	
					TECH APPL:	
				28 MAR 2014	DSGN APPL:	D P SMITH



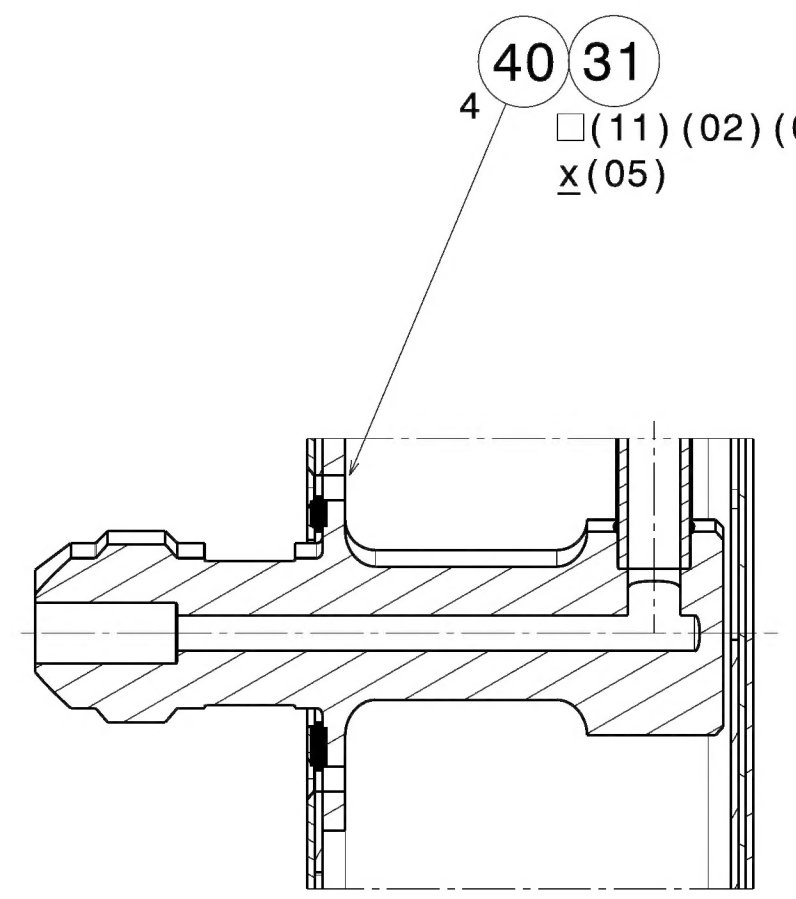
VIEW ON ARROW D
SHOWING EJECTOR (REF 06) ATTACHMENT
TYP 10 POSN
SCALE: 1:1



SECTION C-C
SHOWING ANCHOR NUTS (REF 15)
AND FRAME RIVETS
TYP 10 POSN
SCALE: 1:1



VIEW ON UNDERSIDE
SHOWING OUTLET PLATE (REF 05)



SECTION G-G
THRO' MANIFOLD (REF 11)
SCALE: 1:1

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